



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2666-2
Job Sheet 172164

Part No: D2666-2

Job Qty: 4 ea

Part Name: Saddle, RH, Fwd, Aft, In



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/13/18

Job Tracking No:

Due Date: 3/16/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV D IPP: C 00.11.01 Removed P/O for Powder Coat - in house process EC IPP Rev:D As per Rev D 07-03-19 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea	3/15/18	3/15/18	0.00	0.00	Start Up Machining-1		SBL 18/05/17
100	CNC Vertical Machining	4 pcs	3/15/18	3/15/18	0.10	7.27	HAAS1-2		SBL 18/05/17
110	Mill Conv	4 pcs	3/15/18	3/15/18	0.00	0.62	Mill Conv 1		SBL 18/05/17
120	QC	4 pcs	3/15/18	3/15/18	0.00	0.00	QC2 Machining-1		SBL 18/05/17
130	QC	4 pcs	3/15/18	3/15/18	0.00	0.00	QC8 Machining-1		SBL 18/05/17
140	HandFinish	4 pcs	3/15/18	3/15/18	0.00	0.24	HandFinish1		SBL 18/05/17
150	Powdercoat	4 pcs	3/16/18	3/16/18	0.00	0.14	Powdercoat1		SBL 18/05/17
160	QC	4 pcs	3/16/18	3/16/18	0.00	0.00	QC3		SBL 18/05/17
170	Packaging	4 pcs	3/16/18	3/16/18	0.00	0.00	Packaging3-1		SBL 18/05/17
180	QC21-SA	4 Ea	3/16/18	3/16/18	0.00	0.00	QC21		SBL 18/05/17

Part Op 100 - Program batch number. 1-Inspect part number and batch number are programmed correctly. 4-Machine Step No 1 Descriptions: of Folio and visually inspect as per attached Dimension Sheet 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet 6

110 - Machine Keyway and inspect per attached dimension sheet

150 - START TIME: 9:20 ON T-300 FINISH 9:50 M138839

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D6101-001	Saddle Billet	4 Ea (1 ea)	90-Start up Operation	

S067879 → S072112

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D6101-001	4	49	0

Part Specifications

Specifications could not be found.

Plex 2/13/18 10:49 AM Dart. Gagnon.Michelle



Container No: S072113

Part: D2666-2

Job No: 172164

Serial No/Batch: S072113

Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/17/18

DART AEROSPACE LTD				Work Order: 172164	
Description: 206 Saddle, Inboard, Right side				Part Number: D2666-2	
Inspection Dwg: D2666 Rev: D DSK: Rev:				Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.122	.122	.122	.122	
B	0.100	0.140		.116	.117	.117	.117	
C	2.470	2.510		2.495	2.495	2.496	2.492	
D	0.100	0.180		.135	.135	.135	.135	
E	0.210	0.230		.219	.220	.220	.220	
F	1.313	1.343		1.321	1.322	1.322	1.322	
G	0.240	0.260		.248	.251	.251	.251	
H	0.615	0.685		.643	.650	.650	.650	
I	1.125	1.145		1.135	1.135	1.135	1.135	
J	0.990	1.010		1.003	1.003	1.003	1.003	
K	0.235	0.240		.238	.238	.238	.238	
L	0.510	0.515		.510	.510	.510	.510	
M	0.100	0.120		.110	.110	.110	.110	
N	1.565	1.585		1.575	1.575	1.575	1.575	
O	5.990	6.010		6.000	6.000	6.000	6.000	
P	1.245	1.255		1.250	1.250	1.250	1.250	
Q	2.495	2.505		2.500	2.500	2.500	2.500	
R	0.490	0.510		.501	.501	.500	.500	
S	0.312	0.318		.313	.313	.313	.313	
T	2.495	2.505		2.500	2.500	2.500	2.500	
U	1.357	1.367		1.362	1.362	1.362	1.362	
V	0.315	0.322		.316	.316	.316	.316	
W	0.540	0.560		.550	.550	.550	.550	
X	1.674	1.684		1.680	1.680	1.680	1.680	
Y	0.256	0.262		.257	.257	.257	.257	
Z	0.178	0.198		.188	.188	.188	.188	
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

Measured by: SBL	Date: 18/05/17
Audited by: 9-89	Date:
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	
G	12.03.08	Dimension S and Y revised	KJ	